

Patent claims

1 1. A method of continuously casting metal or metal
2 alloys, especially copper or copper alloys in which the liquid
3 metal flows from a heating vessel through a casting nozzle into the
4 casting pool of a continuous casting apparatus which is provided
5 with a traveling mold, characterized in that the casting nozzle is
6 configured as an immersion tube which projects into the casting
7 pool formed by the traveling mold sides.

1 2. The method according to claim 1 characterized in that
2 the immersion tube is matched in its inclination to the position of
3 the melt level in the casting pool and is optionally controlled by
4 feedback in response thereto.

1 3. The method according to claim 1 or 2 characterized in
2 that the transport belts are slightly inclined with respect to the
3 horizontal, preferably between 3° and 45° and/or have a spacing
4 which is greater than 20 mm.

1 4. The method according to one of claims 1 to 3,
2 characterized in that the liquid molten metal is transferred from
3 the furnace directly into the immersion tube, preferably under
4 pressure.

1 5. A casting device for the continuous horizontal
2 casting of metal, comprised of a furnace (10), a device for
3 transferring the liquid molten metal and a traveling mold,
4 characterized in that the device for transferring the liquid molten
5 metal is an immersion tube (13) which is movable along its
6 longitudinal axis.

1 6. The casting device according to claim 5 characterized
2 in that the immersion tube (13), preferably along its outer
3 surface, has spacing sensors with which the relative position of
4 the immersion tube to the casting pool can be adjustably
5 controlled.

1 7. The casting device according to claim 5 or 6
2 characterized in that the immersion tube is fixed directly with the
3 casting furnace (10, 11) and that the furnace is movable along a
4 path inclined to the horizontal so that the immersion tube (13) is
5 displaceable by the movement of the furnace.

1 8. The casting device according to one of claims 5 to 7
2 characterized in that the immersion tube (13) is arranged with an
3 inclination relative to the longitudinal axis of the casting gap
4 and is displaceable.